

Date: Tuesday, 07/04/2009 3:21:50 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UPPER BLADE SUPPORT AND COVER ASSEMBLY
Job Number	: 47054		
Estimate Number	: 13520		
P.O. Number	:	Part Number	: PB674300121
This Issue	: 07/04/2009 S.O. No. :	Drawing Number	: B6743001 P.10
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 07/04/2009 Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	: 45038	Material	:
Written By	:	Due Date	: 25/04/2009 Qty: 2 Um: Each
Checked & Approved By	: <u>mf 09-04-08</u>		
Comment	: Est Rev:A 08-07-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	PB674300175	Upper Blade Support Ass'y
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Upper Blade Support Ass'y batch: <u>B47062</u> <u>SAD 09-05-01</u>	
✓ 2.0	PB6743001173	Cover Plate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Cover Plate batch: <u>B45919</u> <u>SAD 09-05-01</u>	
✓ 3.0	PB674300185	PB67-43001-85
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) PB67-43001-85 batch: <u>B45007</u> <u>SAD 09-05-01</u>	
✓ 4.0	MS27039110	Screw
	Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s) Screw batch: <u>M110704</u> <u>SAD 09-05-01</u>	
✓ 5.0	NAS1149F0316P	WASHER
	Comment: Qty.: 10.0000 Each(s)/Unit Total : 20.0000 Each(s) WASHER batch: <u>M11117</u> <u>SAD 09-05-01</u>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.05.01	5.1	ADD AN9602D10 (QTY.12). INSTALL 2 SCREWS BETWEEN COVER AND SUPPORT. B# 116985	SM	09-05-01	24	09.05.01	09/05/01	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: PB674300121

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Assemble as per dwg PB67-43001

SAD 09-05-01

(2)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/05/04

(XD)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST431

S 09/05/04

(X2)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/04

Job Completion



MF 09-05-04

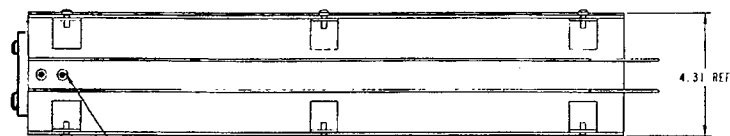
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

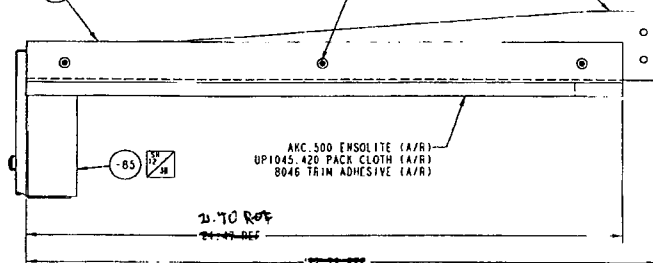


Ø.250 THRU -173
MATCH DRILL WITH HOLE
PATTERN OF -75
MS27039 1-10 SCREW
NAS149F0316P WASHER
2 PLACES

△ MATCH DRILL COVER TO HOLES IN
ANGLE BRACKETS. ATTACH USING
MS27039 1-10 SCREW
NAS149F0316P WASHER
6 PL (3 PL OPP)

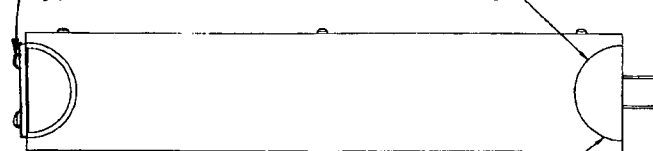
-173

-75



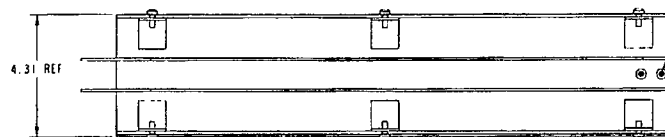
MS27039-1-10 SCREW
NAS149F0316P WASHER
2 PLACES

R1.75 REF



② -21 UPPER BLADE SUPPORT AND COVER ASSEMBLY

SCALE 0.500

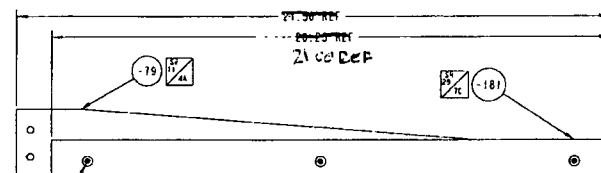


Ø.250 THRU -181
MATCH DRILL -181 WITH
EXISTING HOLE PATTERN
OF -79
MS27039 1-10 SCREW
NAS149F0316P WASHER
2 PLACES

24.23 REF

21.30 REF

21.00 REF



△ MATCH DRILL HOLES IN COVER
TO ANGLE BRACKETS ON
SUPPORT. INSTALL COVER USING
MS27039 1-10 SCREW
NAS149F0316P WASHER
6 PL (3 PL OPP)

-181

-83



② -23 LOWER BLADE SUPPORT AND COVER ASSEMBLY

SCALE 0.500

PREMIER AVIATION, INC.			
2001 Aviation Parkway, Grand Prairie, Texas 75051			
DATE: 08/08	REV: 01	FIG: 01	BY: BT
D:\OSUV8		B67-43001	
SCALE: 1"=1"	NO: 1	SHEET: 10	OF: 45

ORIGINAL